

Wednesday, June 09, 2010 8:42:46 AM



Accept

**Setup Start**

Stop



Start Date: 6/9/2010 **Start Qty:** 8.00

**Cust Item ID:**

Required Date: 6/17/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 7-6-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Work Order ID 59628

Wednesday, June 09, 2010 8:42:46 AM



Page 3

Item ID: D3405-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 6/9/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 59628

Wednesday, June 09, 2010 8:42:46 AM

Page 4

Item ID: D3405-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Assembly

Start Date: 6/9/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 8.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10-6-23	8x	8x	sf
200  Packaging Packaging	Identify as per dwg & Stock Location <u>474</u> Memo	0.00 0.00				10-6-23	8x	8x	sf
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						10/06/24	sf

C210/6/24

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Wednesday, June 09, 2010 8:42:50 AM



Required Date: 6/17/2010

Required Qty: 8.00

D3404-1

GHW Lug

B59691 X8

Location

WA

Loc Qty

10

Loc Code

56832

10

M304S11GA

Purchased

No

150

sf

150.7669

0.154

1.296842

[illegible]

304/316 0.125 Sheet

Location

MAT

Loc Qty

150.7669

Loc Code

114488

22.7669

114799

128

114488

8

W/O:		WORK ORDER CHANGES					
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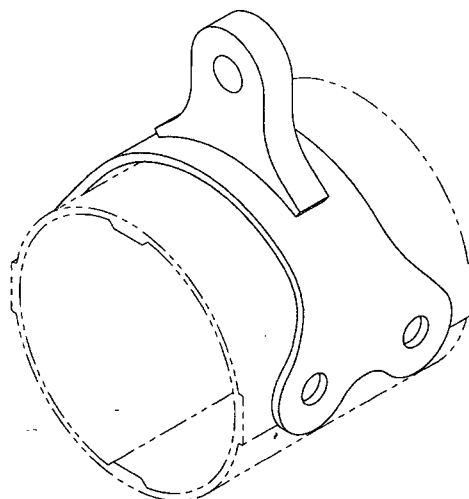
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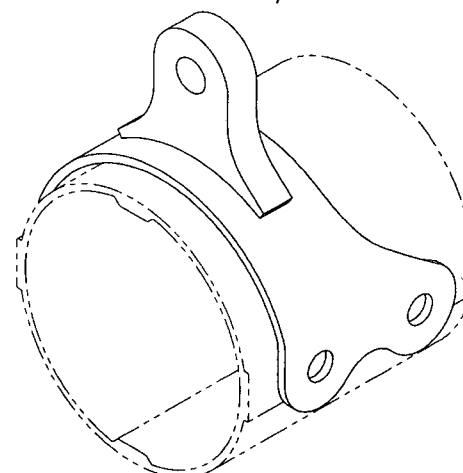
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58628
10-6-09



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19		<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D3404-1
GHW LUGD3405-1
GHW BRACKET4.120^{+0.020}_{-0.000}**D3405-041 LUG ASSEMBLY**

0.500

1/8




w/o 59428

D3404-1
GHW LUGD3405-3
GHW BRACKET4.120^{+0.020}_{-0.000}**D3405-043 LUG ASSEMBLY**

0.500

1/8

RELEASED
08/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE	SCALE
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8

7

6

5

4

3

2

1

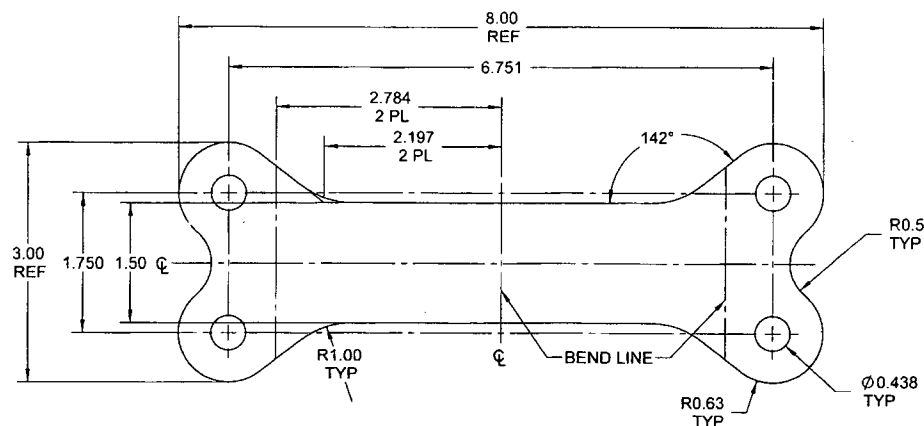
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

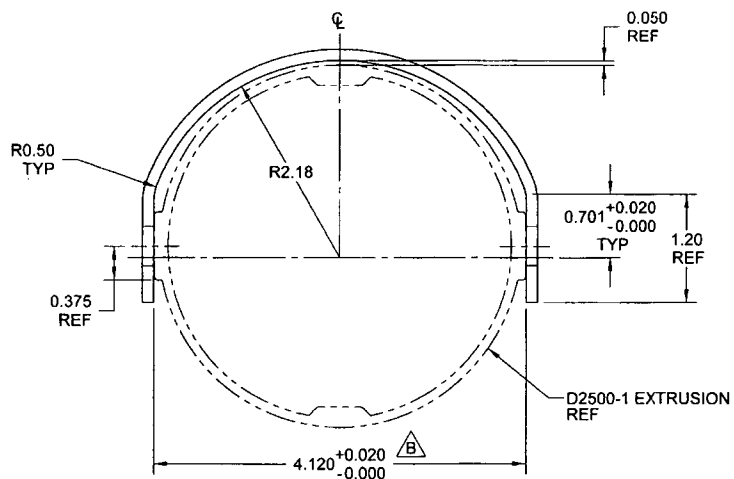
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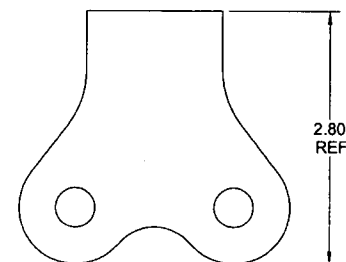
NOTE: Date & initial all entries



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

- NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B SHEET 3 OF 4
MFG. APPR.		TITLE GHW LUG ASSEMBLY	SCALE NTS
APPROVED		<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DE APPR.			
DATE	08.09.19		

u/059628

RELEASED
08/09/19

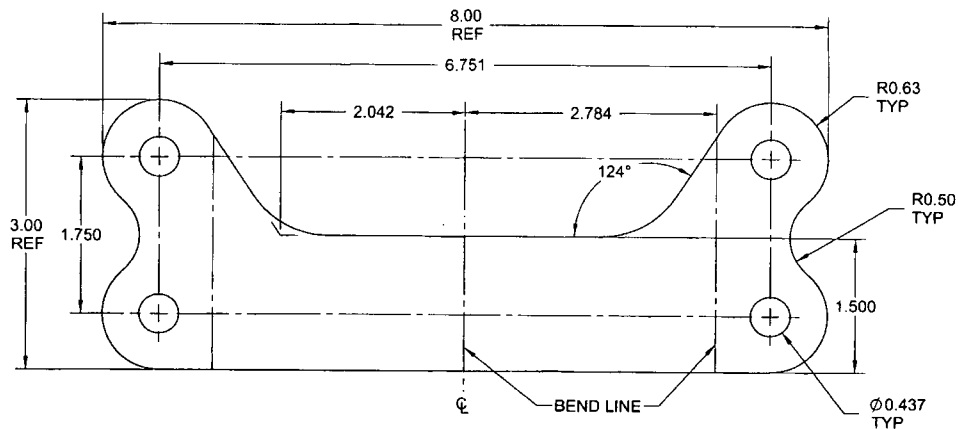
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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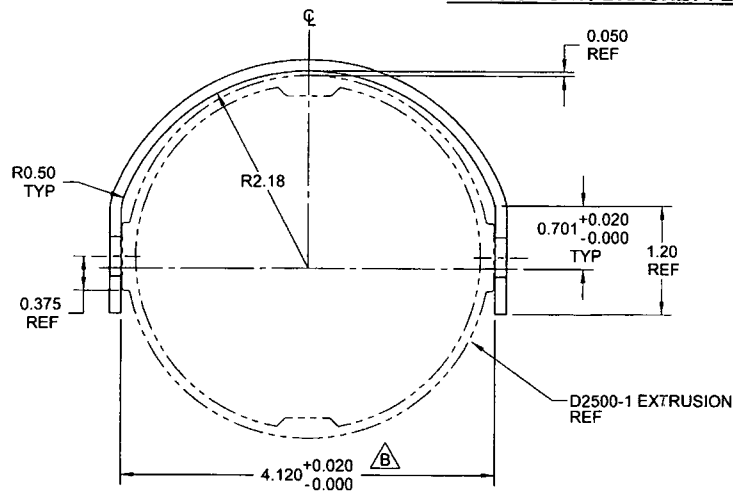
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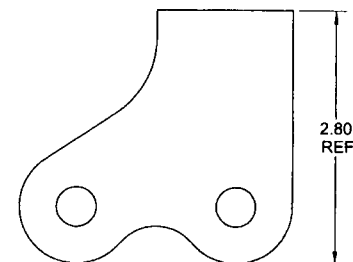


W/O 39428

D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
08/12/18 NV

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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